

Rework per new dwg. prelim-rev B.

Work Order ID 57312

Monday, April 05, 2010 11:59:31 AM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 4/5/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/6/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 04-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3908	A

100 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
TRIM RIVETS 1.185" LONG

~~SAT~~ EP
~~40-04-05~~

EP 10/04/06 (2)

(3)

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

~~Si.alouac~~

(4)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57312

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Page 2

Item ID: D3908-041

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Required Date: 4/6/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

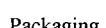
130

Identify as per dwg & Stock Location: S03

0.00

Poly/c (2)

Packaging



Memo

0.00

Packaging



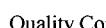
140



QC21- Final Inspection - Work Order Release

0.00

QC



Quality Control

Memo

0.00

MK 10-4-6

*2 row/0
and Eng. table
1 Eng. table*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, April 05, 2010 11:59:31 AM

Work Order ID: 57312



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/5/2010

Required Date: 4/6/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3908-1 		Manufactured	No			100	Each	16.0000	12.0000			

Lug Plate, Aft Crosstube

WarehouseLocation

Main Warehouse

ST095

Loc Qty

16

Loc Code
MF 10-4-5

D3908-3



Manufactured

Stud Receiver, Lower

WarehouseLocation

Main Warehouse

ST095

Loc Qty

8

Loc Code
MF 10-4-5

D3909-5



Manufactured

Eyebolt Stud

WarehouseLocation

Main Warehouse

ST095

Loc Qty

8

Loc Code

PTO →

WarehouseLocation

Main Warehouse

56957

swrap
mf 10-4-7

8

Loc Code

D3910-1



Manufactured

Crosstube Lug

WarehouseLocation

Main Warehouse

ST095

WarehouseLocation

56952

57283

Loc Qty

2

Loc Code

6

12.0000


MF 10-4-5

8 X 57107

4 X 57194

- pulled remaining D3909-S to scrap P.56953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Scrap D3909-S & replace with D3908-S * ADD. ms1784-c413 B# M109031(1x) M111060(2x) B# 57428 * ADD + CBL460 Loop sleeve (6" width x 2 per kit B# + CBL-1240. 16 inches per kit B# D 2690-6 B 53112	MF SP	10-4-7			
			SP	10/4/7			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, April 05, 2010 11:59:31 AM

Work Order ID: 57312



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/5/2010

Required Date: 4/6/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C12A	Purchased	No		100	Each	248.0000	24.0000				
---------	-----------	----	--	-----	------	----------	---------	--	--	--	--

Bolts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST351 248

112314 248

MF 10-4-5

MS21043-3	Purchased	No		100	Each	3,978.000	24.0000			
-----------	-----------	----	--	-----	------	-----------	---------	--	--	--

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

OFFSHORE

FG 80

103691 80

Main Warehouse

ST301 3898

112314 3898

MF 10-4-5

MS20615-4M20	Purchased	No		100	Each	34.0000	36.0000			
--------------	-----------	----	--	-----	------	---------	---------	--	--	--

RIVET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST323 34

113254 34

1114324

1114304

(12x)

SJ 10/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 3

Monday, April 05, 2010 11:59:31 AM

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Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/5/2010

Required Date: 4/6/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149C0332R		Purchased		No		100	Each	629.0000	48.0000			

Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST297	629	
113524	500	
113691	-57	
113737	186	

2010-45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

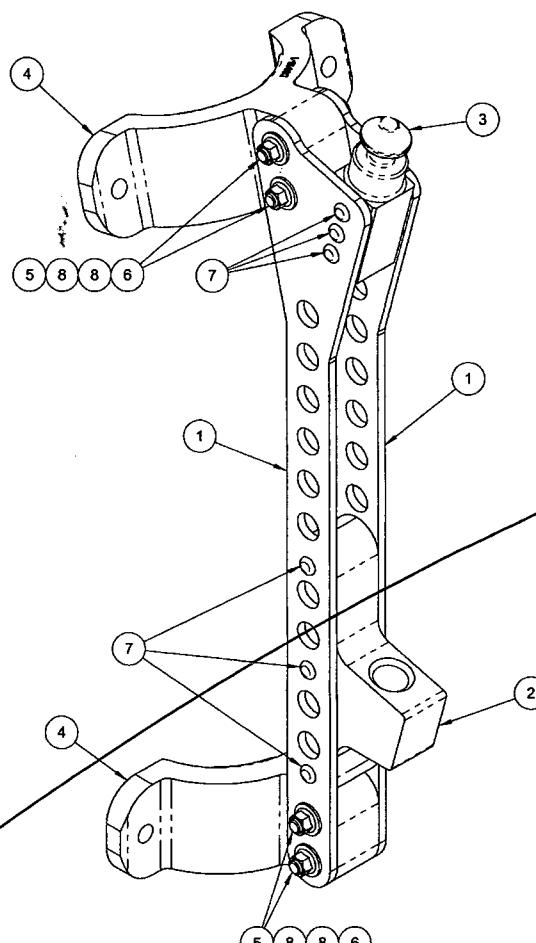
4

3

2

1

ITEM	QTY.	P/N	DESCRIPTION
X	D3908-041		X-TUBE LUG ASSY (AFT)
1	2	D3908-1	AFT X-TUBE LUG PLATE
2	1	D3908-3	STUD RECEIVER LOWER
3	1	D3909-5	EYEBOLT STUD
4	2	D3910-1	X-TUBE LUG
5	4	AN3C12A	BOLT
6	4	MS21043-3	NUT
7	6	MS20615-4M20	RIVET
8	8	NAS1149C0332R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.30 lbs

RELEASED
2010-03-12
JP

A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKSLEY, ONTARIO, CANADA		
CHECKED		DRAWING NO. D3908		
MFG. APPR.		REV. A SHEET 1 OF 4		
APPROVED		TITLE X-TUBE LUG ASSY (AFT) NTS		
DE APPR.		SCALE		
DATE	10.03.04			

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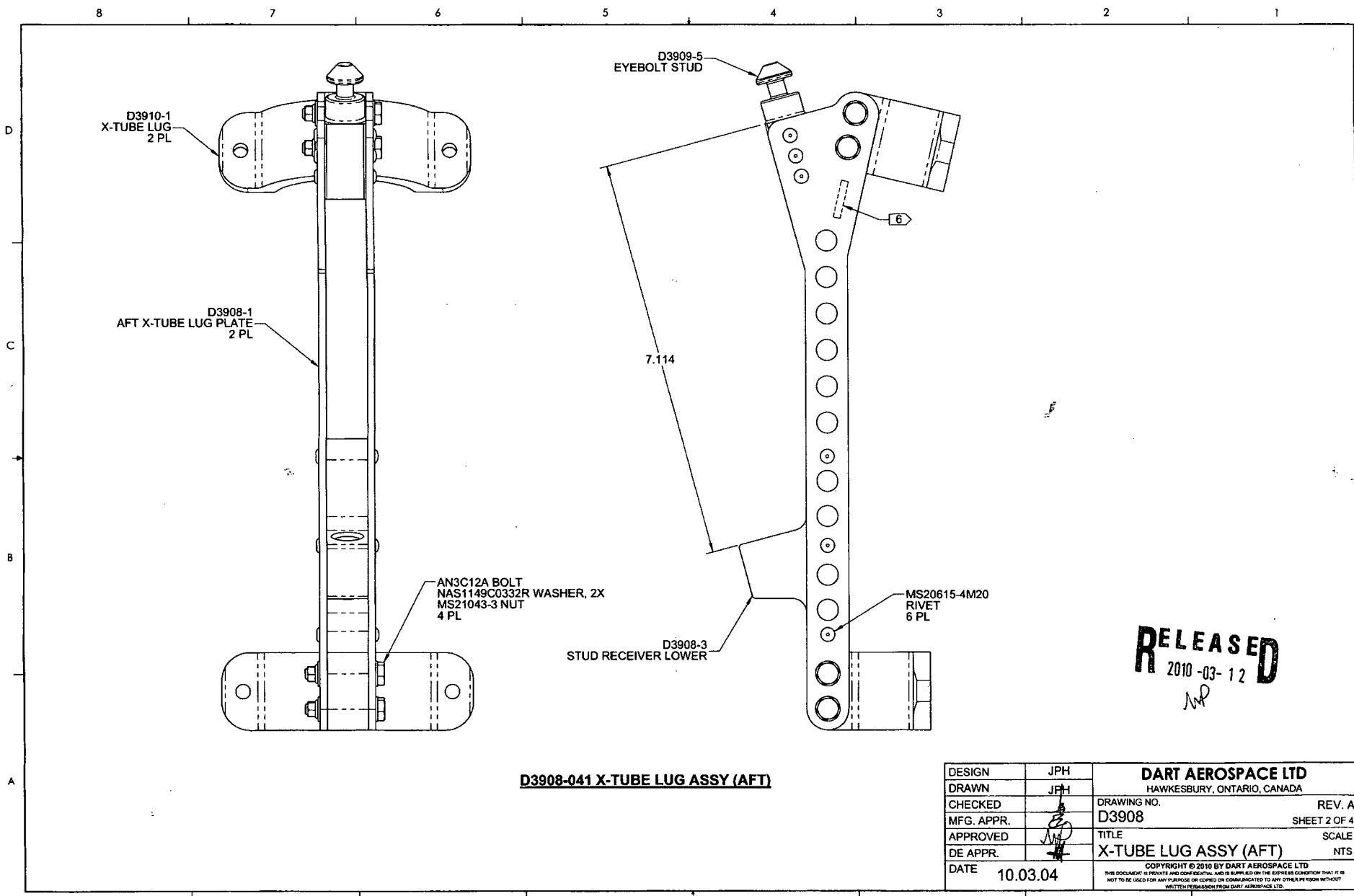
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3908	REV. A
APPROVED		SHEET 2 OF 4	
DE APPR.		TITLE	SCALE
DATE	10.03.04	X-TUBE LUG ASSY (AFT)	NTS

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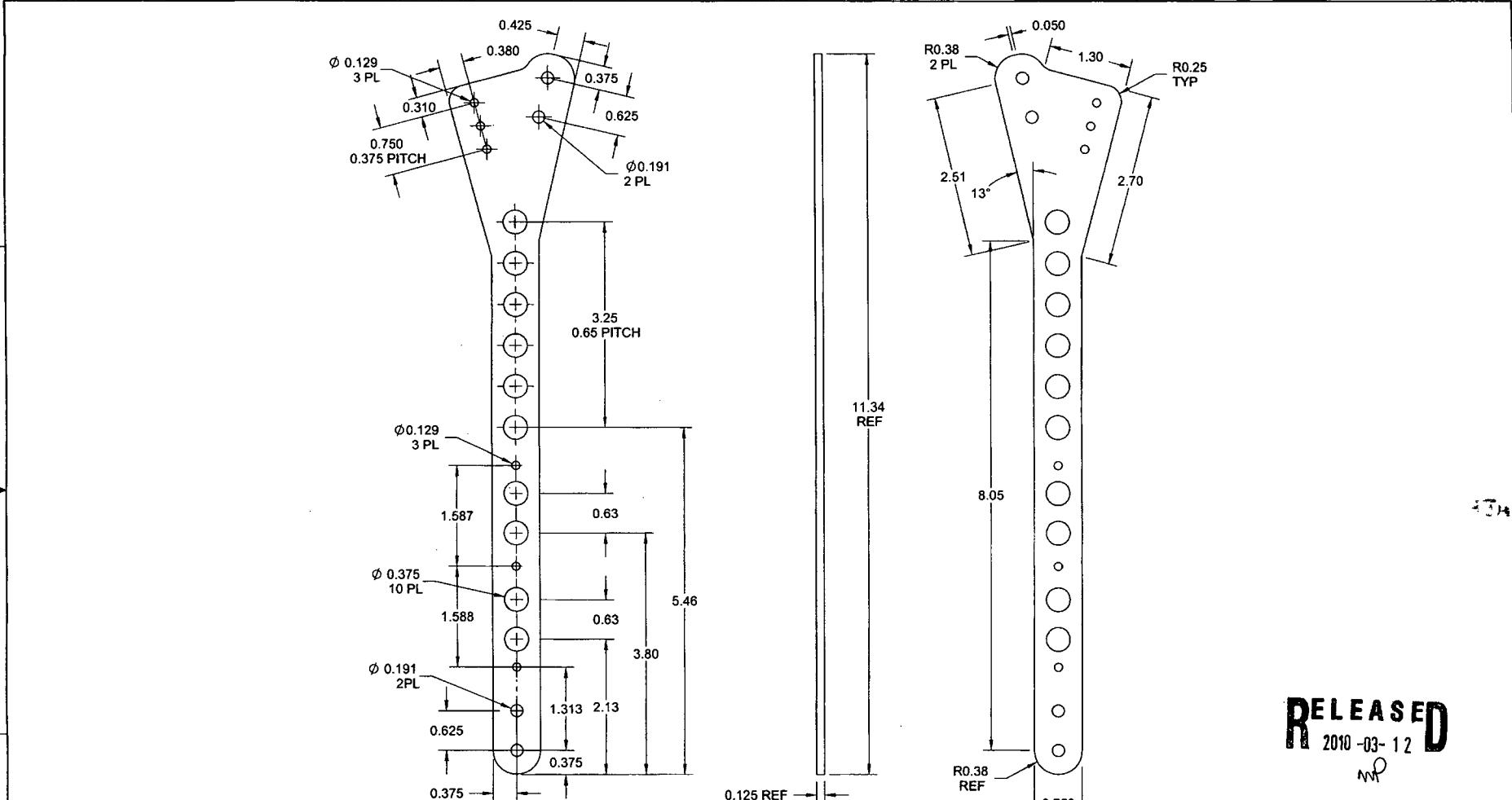
RELEASED
2010-03-12
NP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



RELEASED 2010-03-12

D3908-1 AFT X-TUBE LUG PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, D
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.32 lbs

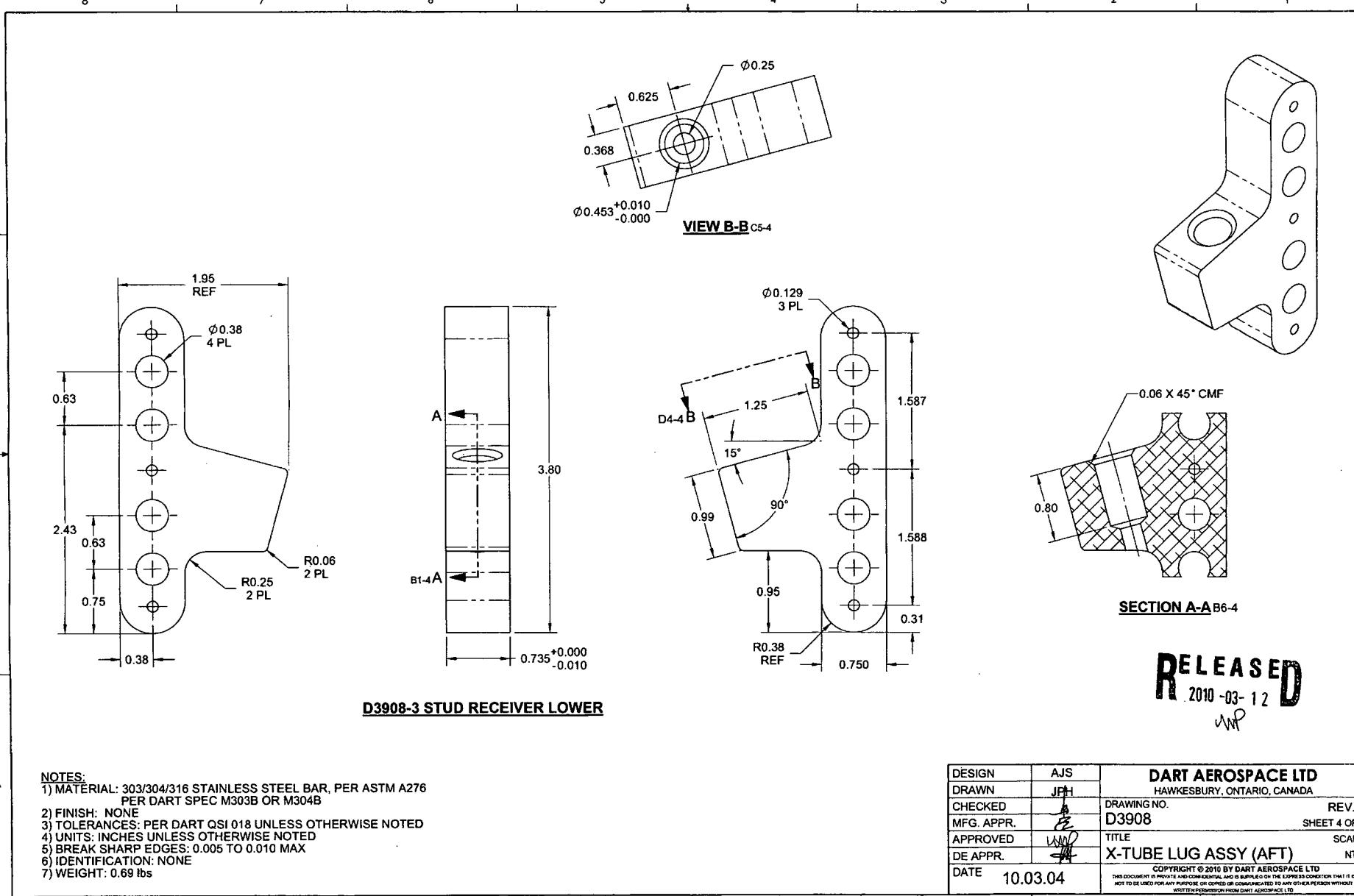
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3908	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	X-TUBE LUG ASSY (AFT)	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3908	REV. A
APPROVED	<i>[Signature]</i>	TITLE	SHEET 4 OF 4
DE APPR.	<i>[Signature]</i>	X-TUBE LUG ASSY (AFT)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

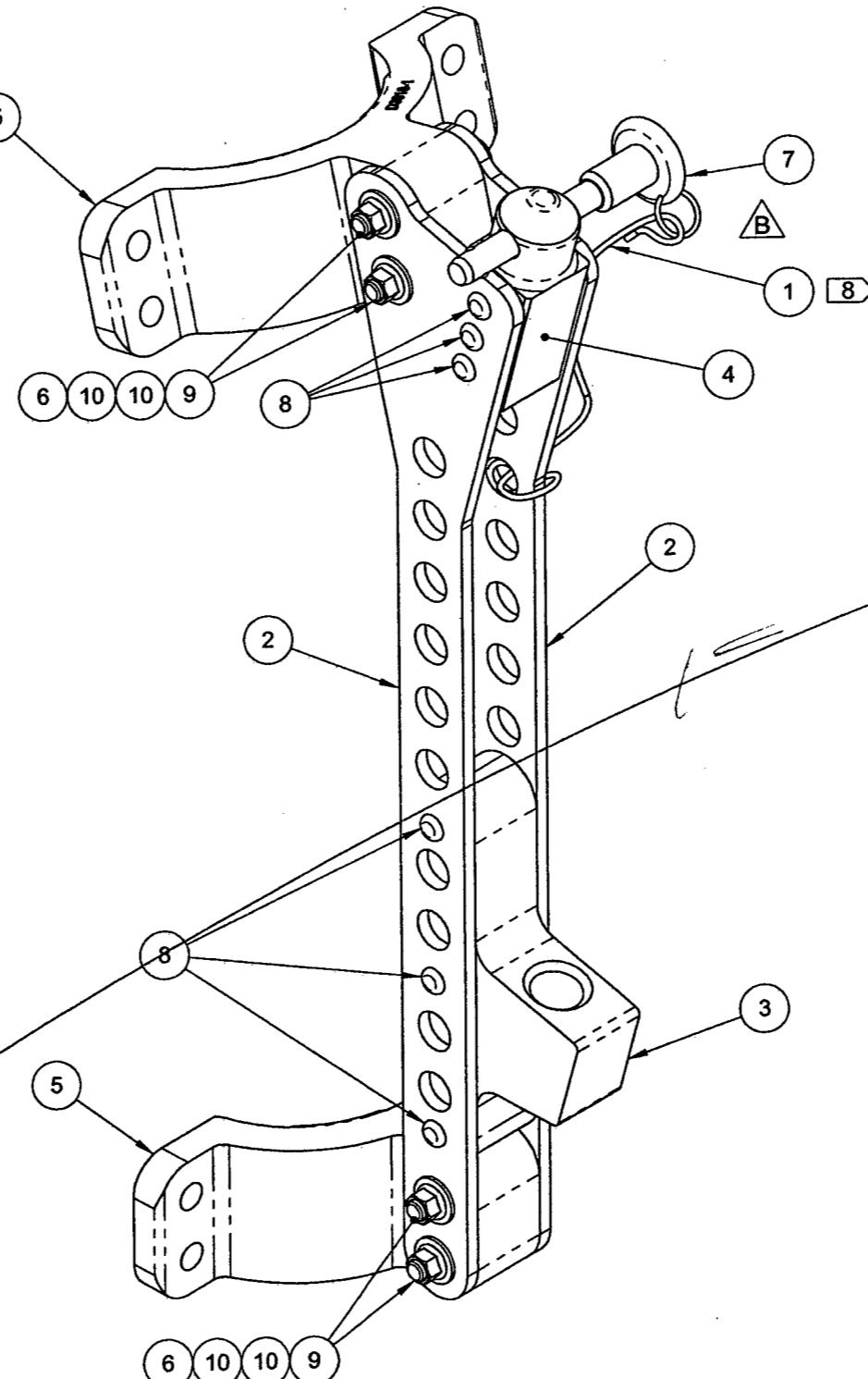
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

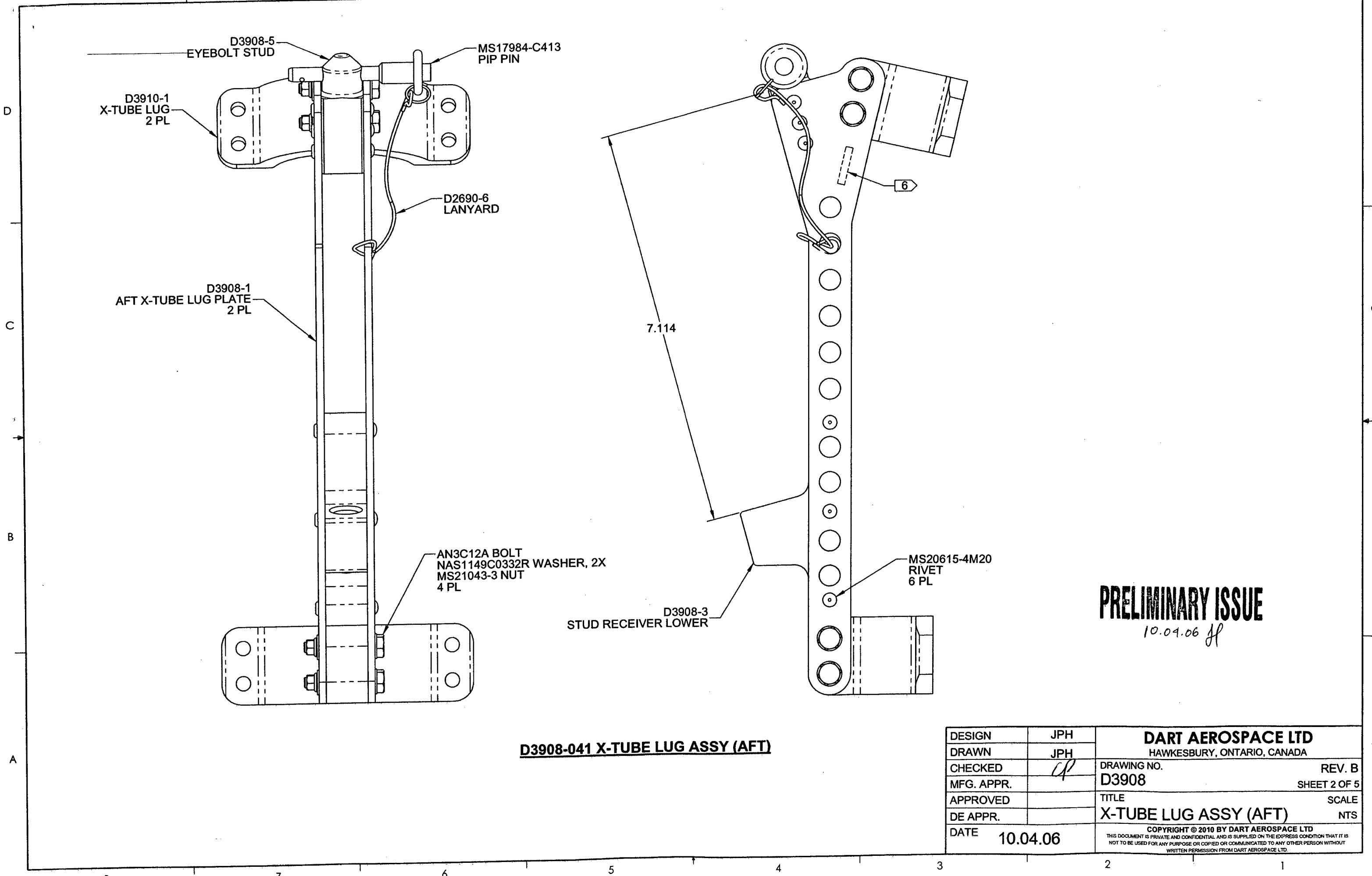
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

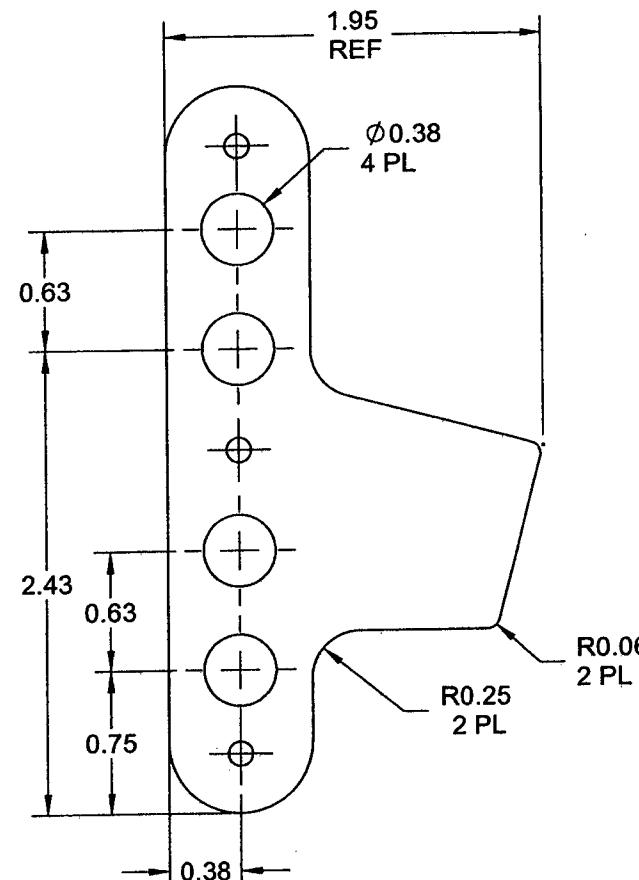
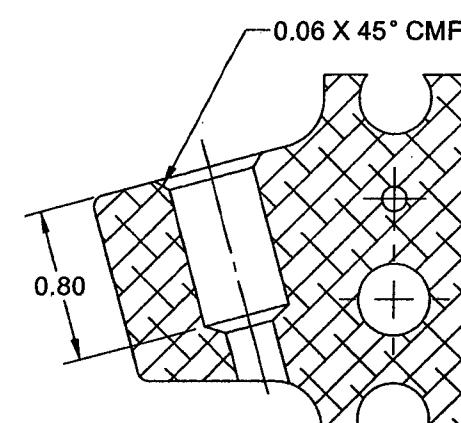
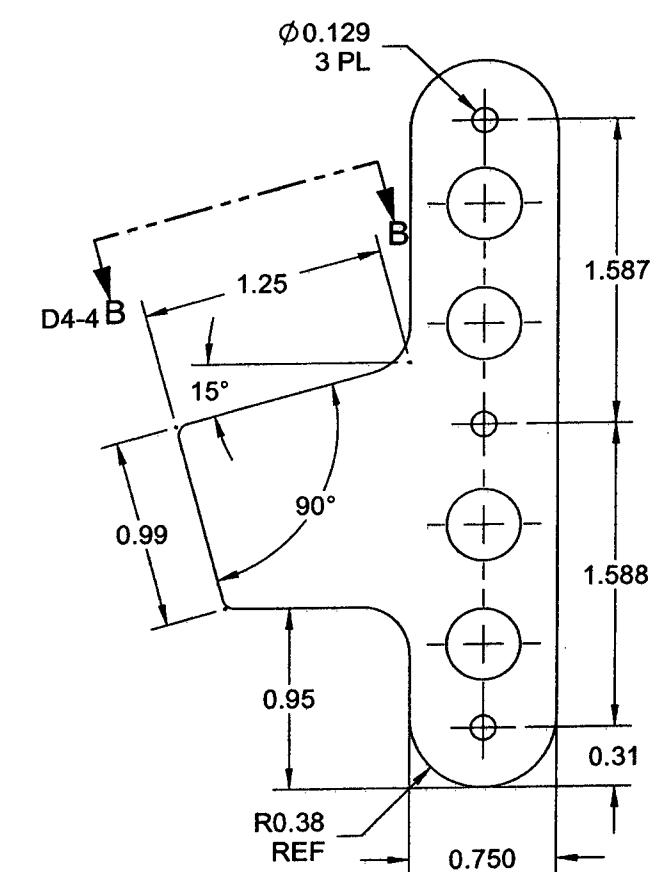
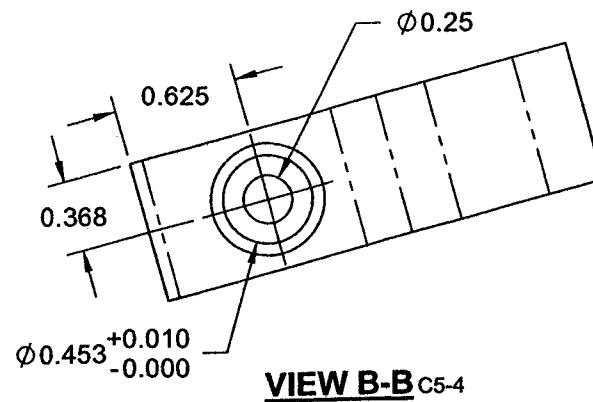
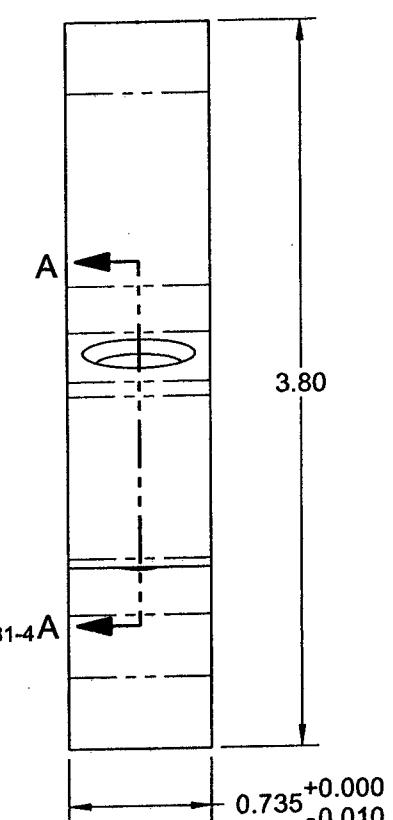
PRELIMINARY ISSUE

10.04.06 JPH

B	BOM: D3909-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.		D3908	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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D

D3908-3 STUD RECEIVER LOWERSECTION A-A B6-4

PRELIMINARY ISSUE
10.04.06 JPH

- NOTES:
 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
 PER DART SPEC M303B OR M304B
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.69 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	JP	
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.04.06	

DRAWING NO. D3908 REV. B SHEET 4 OF 5
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